

Date: Friday, 01/08/2008 10:42:28 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 40893A		
Estimate Number	: 10839		
P.O. Number	:	Part Number	: D22491
This Issue	: 01/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2249 REV. E
First Issue	: //	Project Number	: N/A
Previous Run	: 40486A	Drawing Revision	: E
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/08/2008
Checked & Approved By	: <u>JLD 08.8.05</u>	Qty:	20 Um: Each
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now on Waterjet 07-03-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.0903 sf(s)/Unit Total: 1.8060 sf(s)

304/316 .063 Sheet

Batch: 108090 B8-8-8

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: EProg Rev: EB8-8-828

2-Deburr if necessary

8-8-12 JB

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B8-8-8**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK5 08/08/12counters28

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: PW8/8/1328SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:42:28 AM
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Job Number: 40893A

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



28

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2008/08/14

Job Completion



2008/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

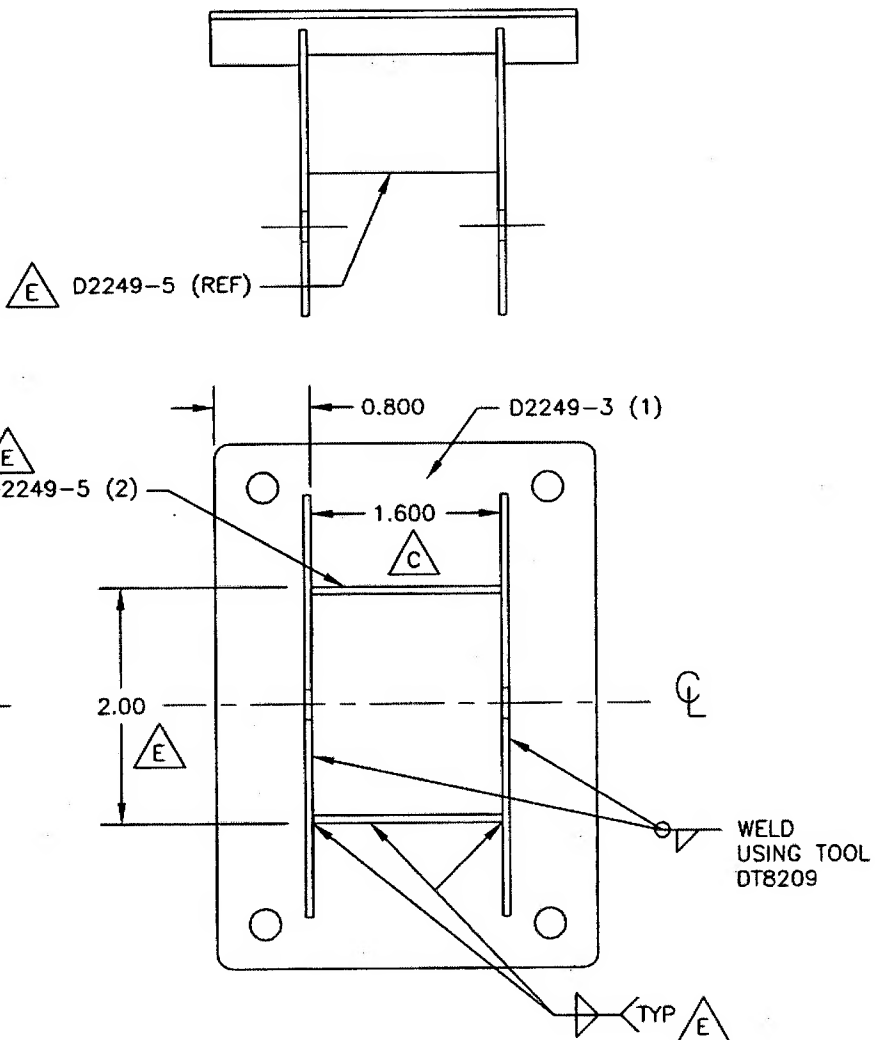
NOTE: Date & initial all entries

DART

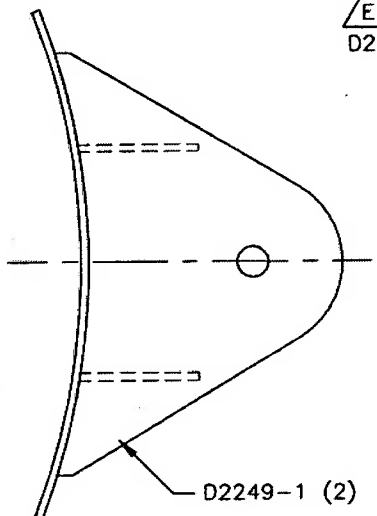
DESIGN	DRAWN BY	DART AEROSPACE LTD	
AE	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED AE	APPROVED RF	DRAWING NO.	REV. E
		D2249	SHEET 1 OF 4
DATE 99.09.20		TITLE FITTING	SCALE NTS

RELEASED
99.10.12 KE

A	94.06.20	NEW ISSUE
B	95.11.30	DIMENSION CHANGE
C	95.12.14	DIMENSION CHANGE
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS
E	99.09.20	ADDED GUSSET

D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



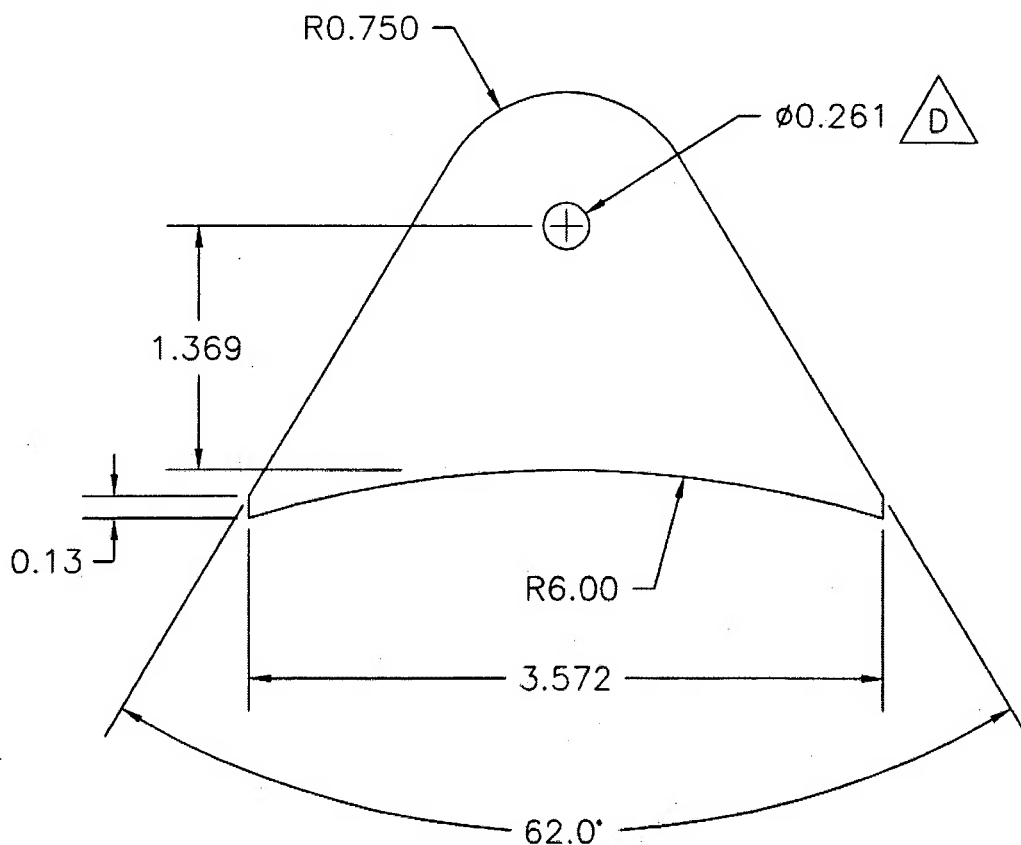
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WORK ORDER
NO. 408121



DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 99.09.20	TITLE FITTING	SCALE 1:1	

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99.10.12 KE



D2249-1 LUG

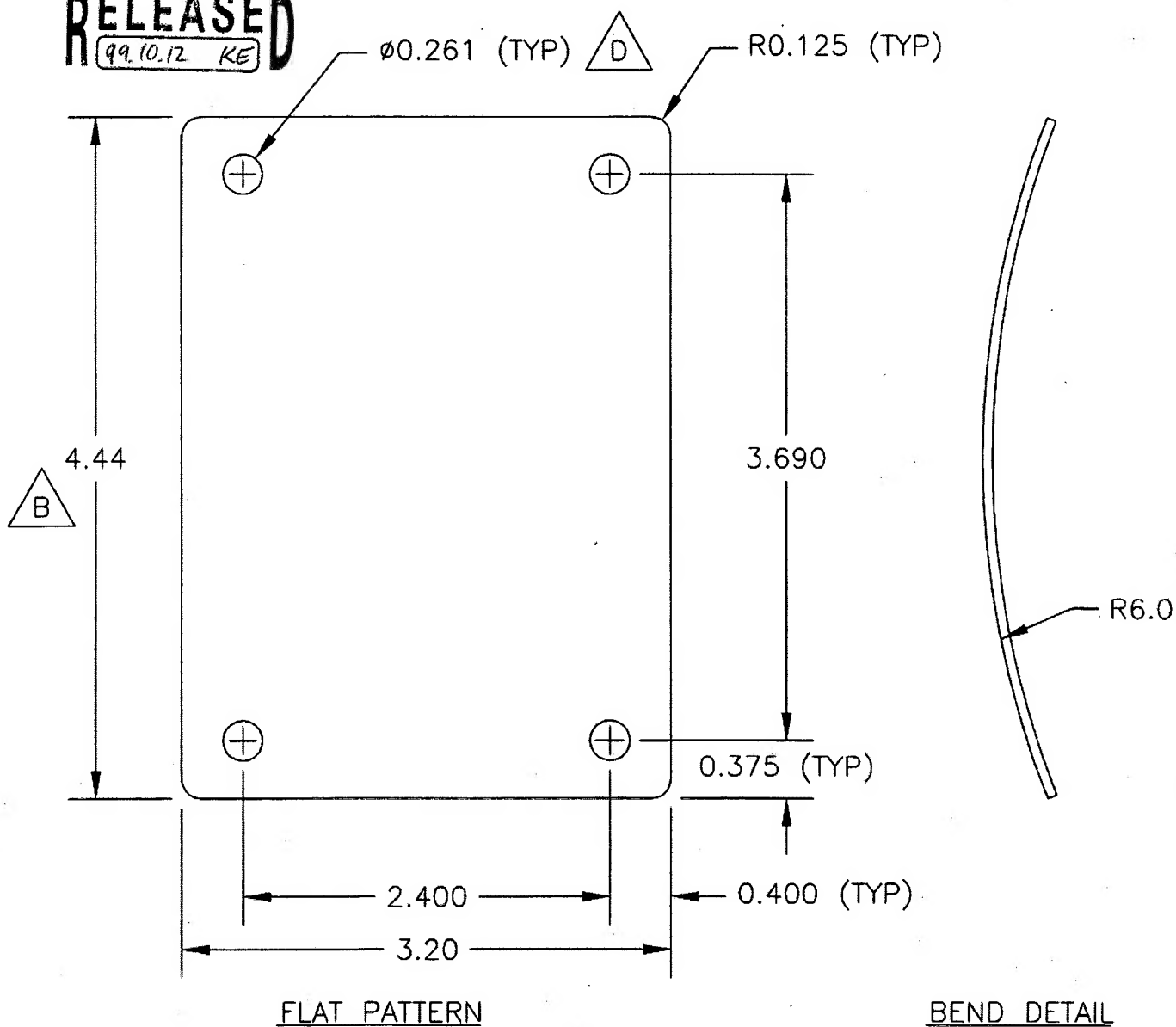
MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
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WORK ORDER
NO. 408937



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DATE 99.09.20		TITLE FITTING	SCALE 1:1

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FLAT PATTERN

BEND DETAIL

D2249-3 BASE PLATE

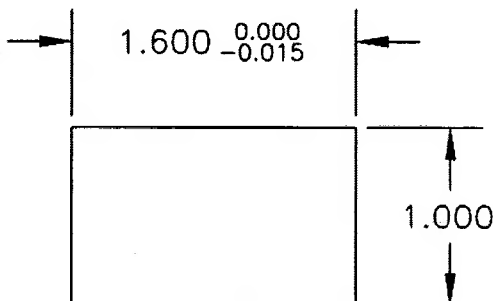
MATERIAL: AISI 304/316 SS 0.063 THICK
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
49.10.12 KE



D2249-5 GUSSET

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WITHOUT NOTICE
WORK ORDER
NO. 40813A

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

